| Work Order ID 1 Tuesday, December 17, 201 | | | *110 | 1385* | | | | | | Page 1 |
|--|----------------------------|--|-------------------------|----------------|------------|--------------|---------------|---------------|------------------|---|
| Item ID: D3529-1 Revision ID: | | | Accept | *N900 | 040 | 100 |)* | Setup Star | 17 | S1* |
| Item Name: Bearpaw Start Date: 12/17/2013 Required Date: 12/27/2013 Reference: | " // 4 | >. *5;* (° *5;* |) | Cust Item : | ID: | | | Stop | ' *N | S2* |
| Approvals: Process P | Plan: MG. | Date: 13-12-17 | Tooling: | D | ate: | |] | Run Star | I/I | R1* ~ |
| QC: | | Date: | SPC (Y/N): | D | ate: | | | Stop | , *N | R2* |
| Sequence ID/ Work Center ID | Operation Description | | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
| Draw Nbr R | evision Nbr | | | | | | | | | |
| D3529 Re | ev A | | | | | | | | | |
| 110 | | | 0.00 | | | | | | | |
| *110* Waterjet | FLOW WATER JET | , | 0.00 | | | | _6 | | | Jm13-12-17 |
| FLOW CNC Waterjet | Memo CUT BLANK | AS PER FILE D3529-1B | | | | | | | | |
| 120 | | | 0.00 | | | | | | | / |
| *120* | HAAS CNC VERTICAL N | IACHINING #1 | | | | | 6 | | | /14/01/17 |
| HAAS 1 | Memo | | 0.00 | | | | | | | 7 |
| HAAS CNC vertical machine #1 | | rial for defects or damage nd Dwg D35293-Deburr | e prior to machining2-M | lachine as per | | | | | | |
| 130 | QC2- Inspect parts off mac | hine FAI/FAIB | 0.00 | | | | | | | 1.0 |
| *1.3U* | | | | | | | | | | 114/01/17 |
| QC | Memo | | 0.00 | | | | | | - | / / / // |

Memo

Quality Control

| DQA: | | | Date: | | | | | | | | | | TRAC |
|--------------------|---------|-----------|------------|----------|----------|------------------------------|----------|---------|-----------------------------|----------|--------------|---------------------------------------|--------------------|
| QA Closed: | | | Date: | | | WORK ORDER NON- | -CC | NFO | RMANCE / UPDATE | Wo | ork Order up | date only | AEROSPĀCE |
| · | | | | | | DISPOSITION | i | | AGAINST | DE | PARTMENT | /PROCESS | |
| Work Orde | er: - | | | | ' | Down rk - | 1 | | Skid-tube Crosstube | | 1 | Water Jet | Engineering |
| Part N | lo. | <u>.</u> | | | | Rework Scrap Use-as-is | | | Machining Small Fab | | 4 | d. Eng. Coor. | Quality Other |
| NCR N | ۱o. ِ | | <u> </u> | | | Suspected Unapproved | | HICH | Large Fab Composite | _ | ince, stor | Supplier | |
| Root | | | | | Desci | ription of work order update | | nitial | Action | | Sign & | | |
| Cause | | Date | Step | Qty | | or non-conformance | Ch | ief Eng | Description | | Date | Verification | QC Inspector |
| Design Doc/Data | | | | - | | · | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | | |
| Handling/Pre | | | | | | | | | | | | | , |
| Material | | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | | |
| Offset/Setup | | Į. | | | | | | | | | | | |
| Process | | | | | | | | | | | | | |
| Supplier | | | 1 | | | | | | | | | | |
| Training | | | | | | | | | | | | | |
| Transport | | | | | | | | | | | | | |
| Unapproved | | | | <u> </u> | <u> </u> | | | | | | ļ | | |
| | | | | | | | FA | ULT CA | TEGORY | | | | |
| Landi | ng (| 3 | | | | General | | 1. | | _ | ٦ | | 7 |
| | | Bending | | | | Bend | | 1 ' | Program | <u> </u> | Outside Dim | <u> </u> | Pressure/Forced |
| | L | Centre No | ot Concei | ntric | | BOM/Route | | Grain | | - | Over/Under | — | Set-up |
| | | Cracks | | | _ | Broken/Damage/Defect | | Hardw | | \vdash | Part Incorre | ├ | Temperature/Cure |
| | | Crimp/Kir | nk/Ripple | :/Wave | | Burrs | <u> </u> | 1 ` | tion Incomplete/Unqualified | <u> </u> | Part Lost/M | issing | Weld |
| <u> </u> | L | Cuffs | | | L | Contamination | _ | 4 | tions Incomplete/Unclear | <u> </u> | Part Moved | L | Wrong Stock Pulled |
| | L | Crushing | | | | Countersink | <u></u> | 1 | gned/off center | <u> </u> | Positioned \ | _ | ٦٠٠٠ |
| | | Heat Trea | | | | Cut Too Short | | Mislab | | | Power Loss/ | 'Surge | Other |
| | <u></u> | Inspectio | n Strip in | Tube | | Drawing | <u></u> | Misrea | | | | • **** | |
| | L | Marks/Cl | | | | Drill Holes | \vdash | Off-set | | | | | |
| | | Turning S | equence | | L | Finish | | 4 | Calibration | | | | |
| | 1 | Wave/Tw | ist in Tul | oe | | Fit/Function | 1. | Out of | Sequence | | | · · · · · · · · · · · · · · · · · · · | |

| Work Order ID 🗆 | L1 | .038 | 5 |
|-----------------|----|------|---|
|-----------------|----|------|---|

Quality Control

110385

Page 2

Tuesday, December 17, 2013 9:21:44 AM Accept Item ID: D3529-1 Setup Start *N900040100* **Revision ID:** Stop **Item Name:** Bearpaw Start Qty: 5.00 **Start Date:** 12/17/2013 **Cust Item ID:** Reg'd Oty: '5.00 **Required Date:** 12/27/2013 **Customer:** Reference: Start Run Process Plan: Date: Tooling: Date: **Approvals:** Stop Date: SPC (Y/N): Date: QC: Sequence ID/ Set Up/ **Tool ID** Tool # Plan Operation Accept Reject Reject Insp. **Qty** Qty Stamp **Work Center ID Description** Code Number **Run Hours** 0.00 140 OC8- Inspect parts - second check D. a 14/01/17 *140* 0.00 OC Memo Quality Control 0.00 150 Identify as per dwg & Stock Location: 61 *150* 4.109611 Packaging Memo Packaging 160 OC21- Final Inspection - Work Order Release 0.00) 14-01-20 *160* OC 0.00 Memo

| DQA: | | <u> </u> | Date: | | | | | | | | | | TRACT |
|---------------|--|---------------------|------------------|---------|----------|------------------------------|----------|---------|-----------------------------|---------------|------------------|---------------|--------------------|
| | | | | | | WORK ORDER NON- | -CC | NFO | RMANCE / UPDATE | | | – | AEROSPACE |
| QA Closed: | | | Date: | | | | | | | W | ork Order up | date only | |
| Work Orde | ar. | • | | | | DISPOSITION | | | AGAINST | DE | PARTMENT/ | PROCESS | |
| WOIK OIG | - | | | | _ | Rework | | | Skid-tube Crosstube | |] | Water Jet | Engineering |
| Part N | lo. | | | | | Scrap | ı | | Machining Small Fab | $\overline{}$ | Pro | d. Eng. Coor. | Quality |
| | - | 1 | | | | Use-as-is | | | noforming Finishing | - | 1 | e/Packaging | Other |
| NCR I | No | | | | | Suspected Unapproved | | | Large Fab Composite | | | Supplier | |
| Root | | | | | Desci | ription of work order update | | nitial | Action | | Sign & | | |
| Cause | | Date | Step | Qty | | or non-conformance | Ch | ief Eng | Description | | Date | Verification | QC Inspector |
| Design | | | | | | | | | | | | | |
| Doc/Data | | | | | | | İ | | | | | | |
| Equip/Tooling | | | | | | | ļ | | | | | | |
| Handling/Pre, | 3 | | | | | | | | | | | | |
| Material 🖆 | Ш | | | |]] | | | | | | | : | |
| Operator | Щ | | | | | | ĺ | | | | | | |
| Offset/Setup | Ш | | | | | | | | | | | | |
| Process | Щ | | | İ | | | | | | | | | |
| Supplier | \sqcup | | ļ | | | | ļ | | | | | | |
| Training | Ш | | | | | | | | | | | | |
| Transport | Ш | | | | | | | | | | | • | |
| Unapproved | | | <u> </u> | | <u> </u> | | | | TECODY | | <u> </u> | <u> </u> | |
| | | | | | | | FA | ULI CA | TEGORY | | | | |
| Landi | | l | | | _ | General | | 11:-/ | Program | | Outside Dim | onsions [| Pressure/Forced |
| | Н | Bending | - . Caaa- | | - | Bend BOM/Route | \vdash | Grain | riogiani | \vdash | Over/Under | <u> </u> | Set-up |
| | | Centre No | ot Concer | TUTIC | | Broken/Damage/Defect | \vdash | Hardwa | ara | | Part Incorre | _ | Temperature/Cure |
| | \vdash | Cracks Crimp/Kir | nk/Dinnla | /\A/~v~ | - | Burrs | - | ł | tion Incomplete/Unqualified | - | Part Lost/Mi | | Weld |
| | \vdash | Cuffs | ik/ kibbie | y wave | \vdash | Contamination | \vdash | 1 ' | tions Incomplete/Unclear | \vdash | Part Moved | - | Wrong Stock Pulled |
| | | Crushing | | | \vdash | Countersink | - | 4 | gned/off center | \vdash | Positioned V | ∟ Vrong | |
| | | Heat Trea | nt . | | | Cut Too Short | \vdash | Mislab | | | Power Loss/ | _ | Other |
| 1 | \vdash | Inspectio | | Tube | - | Drawing | - | Misrea | | L | ٦. ١.٠٠٠ - ١٠٠٥/ | /0- | 1 |
| | | Marks/Ch | · · | | | Drill Holes | | Off-set | | | | | |
| 1 | | Turning S | | | | Finish | | 1 | Calibration | | | ·· | |
| | | Wave/Tw | • | | | Fit/Function | | 4 | Sequence | | | | |

Tuesday, December 17, 2013 9:21:42 AM

Work Order ID:

110385

Parent Item:

D3529-1

Parent Item Name:

Bearpaw

Start Date: 12/17/2013

Required Date: 12/27/2013

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP Rev:A New Issue 06-06-28 JLM

IPP Rev:B New Manufacturing Method 08-11-27 Verified By:EC

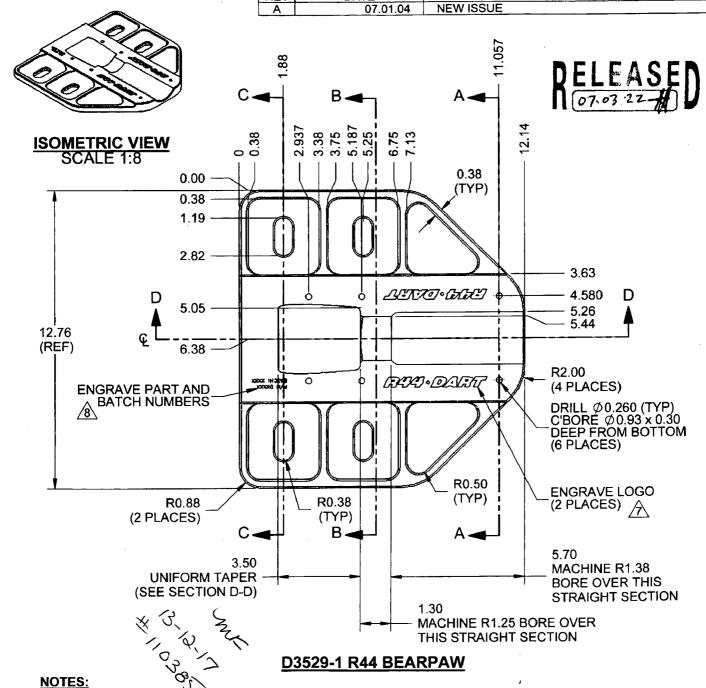
| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|-----------|
| MUHMWB10 | | Purchased | No | | | 100 | sf | 778.0282 | 1.265 | H | . 2 | | |
| UHMW 1" Black - 48"x12 | 20" | | | | | | | | | | 13 | | JM13-12-1 |
| Tivar Mfg.#52480104 | | | | Location | | Loc Oty | Lo | oc Code | | | | | |
| | | | | MAT018 | | 778.0281795 | | | | | | | |
| | | | | 121 | 278 | 9.62817947 | | | | | | | |
| | | | | 122 | 2575 | 47.6 | | | | | | | |
| | | | | 123 | 3229 | 53 | | | | | | | |
| | | | | 123 | 3704 | 63.8 | | | | | | | |
| | | | | 123 | 3949 | 6.96 | | | | | | | |
| | | | | 124 | 1382 | 197.12 | | | | | | | |
| | | | | 124 | 1758 | 17.52 | | | | | | | |
| | | | | 125 | 5137 | 170.4 | | | | | | | |
| | | | | m1 | 26748 | 6 | | | | | | | |
| | | | | m1 | 27491 | 206 | | | 1271 | 191 | | | |

| DQA: | | | Date: | | _ | WORK ORDER NON | - | .N.F.O.1 | DD 4 A DI CE / 11 | IDD ATE | | | | • | TRAG |
|-----------------------|------------------|-----------|------------|-------|------|------------------------------|-----|----------|-------------------|---------------------|-----|--------------|---------------|---------|--------------------|
| QA Closed: | | | Date: | | | WORK ORDER NON- | -CC | ONFOI | RMANCE / U | | Wd | ork Order up | odate only | ٦ | AEROSPACE |
| QA Closed. | | | Dute. | | | | | | | | | . • | | | |
| Work Orde | er: | | | | | DISPOSITION | ı | | | AGAINST | DEI | PARTMENT, | PROCESS | | |
| | | | | | | Rework | | | Skid-tube | Crosstube | | | Water Jet | | Engineering |
| Part N | lo. | | | | | Scrap | | | Machining | Small Fab | | | d. Eng. Coor. | 4 | Quality |
| | | | | | | Use-as-is | | Thern | noforming | Finishing | | Rec/Stor | re/Packaging | 4 | Other |
| NCR I | ۱o. _. | | | | | Suspected Unapproved | | | Large Fab | Composite | | | Supplier_ | _ | |
| Root | | , | | | Desc | ription of work order update | | nitial | Ac | tion | | Sign & | | | |
| Cause | | Date | Step | Qty | | or non-conformance | Ch | ief Eng | Desc | cription | | Date | Verification | \perp | QC Inspector |
| Design | | | | | | ; | | | | | | | | ١ | |
| Doc/Data | Ш | | | | | | } | | | | | | | | |
| Equip/Tooling | | , | | | | | | | | | | | | | |
| Handling/Pre | Ш | | | | | | | | | | | | | | |
| Material | Ш | | | | | | | | | | | | | | |
| Operator | _ | | | | | | | | | | | · | | | |
| Offset/Setup | | | | | | | 1 | | | | | | | - | |
| Process | | | | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | | | | |
| Training Transport | H | | | | | | | | | | | | | ı | |
| Unapproved | H | | | | | | 1 | | | | | | | ١ | |
| опарріочеа | | | l | l | 1 | | FA | ULT CA | TEGORY | | | | | | 10.40 |
| Landi | ng (| Gear | | | | General | | | | (1) | | | | | |
| | | Bending | | | | Bend | | Folio/f | Program | | Г | Outside Dim | ensions | | Pressure/Forced |
| | | Centre No | ot Concer | ntric | | BOM/Route | | Grain | | | | Over/Under | tolerance | | Set-up |
| | | Cracks | | | | Broken/Damage/Defect | | Hardwa | are | | | Part Incorre | cí [| | Temperature/Cure |
| | | Crimp/Kir | nk/Ripple | /Wave | | Burrs | | Inspect | ion Incomplete/L | J nqualified | | Part Lost/Mi | issing | | Weld |
| | | Cuffs | | | | Contamination | | Instruc | tions Incomplete/ | /Unclear | | Part Moved | | | Wrong Stock Pulled |
| | | Crushing | | | | Countersink | | Misali | gned/off center | | | Positioned V | Wrong _ | | |
| | | Heat Trea | at | | | Cut Too Short | | Mislab | eled | | | Power Loss/ | 'Surge | | Other |
| | | Inspectio | n Strip in | Tube | | Drawing | | Misrea | d | | | | | | |
| | _ | Marks/Ch | | | L | Drill Holes | | Off-set | | | | | | | |
| | L | Turning S | equence | | L | Finish | | 4 | Calibration | | | | | | |
| | | Wave/Tw | ist in Tul | oe - | | Fit/Function | | Out of | Sequence | | | | | | |

Z.



| DESIG | BI | DRAWN BY | DART AEROSPAC HAWKESBURY, ONTARIO, C | |
|-------|-----|----------|---|------------------------|
| CHEC | ŒD3 | APPROVED | DRAWING NO. | REV. A SHEET 1 OF 2 |
| DATE | 07. | 01.04 | TITLE R44 BEARPAW | SCALE 1:4 |
| REV | | DATE | DESCRIPTION | |



1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00 THICK (MACHINE TO 0.950)

2) FINISH: NONE

3) PART IS SYMMETRIC ABOUT € 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

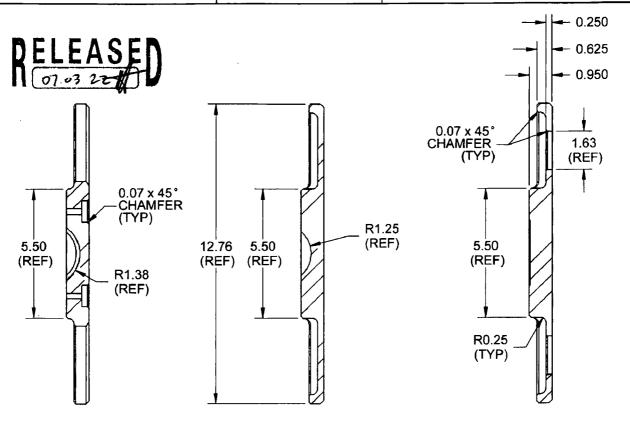
5) ALL DIMENSIONS ARE IN INCHES
6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
7) ENGRAVE LOGO TO MAX DEPTH OF 0.012 AT LOCATION SHOWN

8) ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010 AT LOCATION SHOWN

| DQA: | | | Date: | | | | | | | | | | |
|---------------|--------------|-----------|------------|----------|----------|---|-----|----------------------|--------------------|------------|---------------|---------------------------------------|--------------------|
| | | | | | | WORK ORDER NON- | -CC | ONFO | RMANCE / UI | | | | AEROSPACE |
| QA Closed: | | | Date: | | | 112 T T 1112 1112 1112 1112 1112 1112 1 | | | | v | /ork Order up | date only | |
| Work Orde | er: | | | | | DISPOSITION | | | | AGAINST D | EPARTMENT | PROCESS | |
| | • | | | | _ | Rework | | | Skid-tube | Crosstube | 7 | Water Jet | Engineering |
| Part N | lo. | | | | | Scrap | | | Machining | Small Fab | Pro | d. Eng. Coor. | Quality |
| | • | | | | | Use-as-is | | Thern | noforming | Finishing | Rec/Stor | e/Packaging | Other |
| NCR N | ۱o۰ | | | | | Suspected Unapproved | | | Large Fab | Composite | | Supplier | |
| Root | | | | | Desc | ription of work order update | Ī | nitial | Act | ion | Sign & | · · · · · · · · · · · · · · · · · · · | |
| Cause | | Date | Step | Qty | | or non-conformance | Ch | ief Eng | Descr | iption | Date | Verification | QC Inspector |
| Design | | | | | | | | | | | | | |
| Doc/Data | | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | , | |
| Handling/Pre | | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | |
| Operator | | | | | | | | | ļ | | | : | |
| Offset/Setup | | | | | | | | | | | | | |
| Process | | | | | | | | | | | | | |
| Supplier | | | i | | | | İ | | | | | | |
| Training | | | | | | | | | | | | | |
| Transport | | | | | | | 1 | | | | | | |
| Unapproved | | | <u> </u> | <u> </u> | <u> </u> | | FΔI | UTCA | TEGORY | | | | |
| Landi | nø (| Gear | | | | General | 1// | OLI CA | 1200111 | | | | |
| | _ | Bending | | | | Bend | | l _{Folio/P} | Program | | Outside Dim | ensions [| Pressure/Forced |
| i | | Centre No | ot Concer | ntric | | BOM/Route | | Grain | | <u> </u> | Over/Under |) | Set-up |
| | \vdash | Cracks | | | | Broken/Damage/Defect | | Hardwa | are | <u> </u> | Part Incorred | :i | Temperature/Cure |
| | | Crimp/Kir | nk/Ripple | /Wave | | Burrs | | 4 | ion Incomplete/Ur | ngualified | Part Lost/Mi | ssing | Weld |
| | | Cuffs | | • | | Contamination | | Instruct | tions Incomplete/l | Jnclear | Part Moved | | Wrong Stock Pulled |
| | Г | Crushing | | | | Countersink | | 4 | gned/off center | <u> </u> | Positioned V | Vrong | _ |
| | | Heat Trea | at | | | Cut Too Short | | Mislabe | eled | | Power Loss/ | Surge | Other |
| | | Inspectio | n Strip in | Tube | | Drawing | | Misrea | d | _ | | | |
| | | Marks/Ch | natter | | | Drill Holes | | Off-set | | | | | |
| | | Turning S | equence | | | Finish | | Out of | Calibration | | | | |
| | | Wave/Tw | ist in Tub | oe . | | Fit/Function | | Out of | Sequence | | | | |



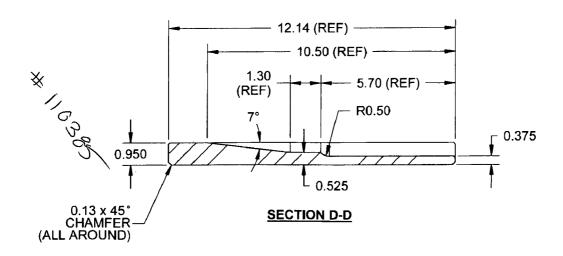
| DESIGN | DRAWN BY | DART AEROSI HAWKESBURY, ONTA | - · · |
|---------|----------|---------------------------------|------------------------|
| CHECKED | APPROVED | D3529 | REV. A SHEET 2 OF 2 |
| DATE 07 | .01.04 | TITLE R44 BEARPAW | SCALE 1:4 |



SECTION A-A

SECTION B-B

SECTION C-C



| DQA: | | | Date: | | | | | | | | | | TO ACT |
|-------------------------------|----------|------------|------------|-------|------|------------------------------|-----|------------|----------------------------|-----------------------|----------------|---------------|--------------------|
| | | | | | | WORK ORDER NON | -CC | NFO | RMANCE / UPDATE | | | | AEROSPACE |
| QA Closed: | | | Date: | | | | | | | Wo | ork Order up | date only | |
| | | | | | | DISPOSITION | | | AGAINST | DEI | PARTMENT | PROCESS | |
| Work Orde | r: _ | | | | | _ | , | | | _ | · | | , <u> </u> |
| | | | | | | Rework | 1 1 | | Skid-tube Crosstube | $\boldsymbol{\vdash}$ | | Water Jet | Engineering |
| Part No | o | | | | | Scrap | | | Machining Small Fab | _ | | d. Eng. Coor. | Quality |
| | | | | | | Use-as-is | | Thern | noforming Finishing | - | Rec/Stor | re/Packaging | Other |
| NCR N | o | | | | | Suspected Unapproved |] | | Large Fab Composite | | | Supplier | |
| D | _ | | <u>1</u> | 1 3 | Dasa | | - | امنانما | Action | | Cian 9 | | |
| Root | | Data | Char | O4 | Desc | ription of work order update | 1 | nitial | Action | | Sign & Date | Verification | QC Inspector |
| Cause | \dashv | Date | Step | Qty | | or non-conformance | Cn | ief Eng | Description | | Date | verincation | QC IIIspector |
| Design | \dashv | | | | | | | | | | | | |
| Doc/Data | \dashv | | | | | | l | | | | - | | |
| Equip/Tooling Handling/Pre | \dashv | | | | | | Į. | | | | | | |
| ! T | \dashv | | | | | | 1 | | | | | | |
| Material | ᅦ | | | | | | | | | | | | |
| Operator Offset/Setup | ᅱ | | | | | • | | | | | | | |
| Process | \dashv | | | | | | | | | | | | |
| Supplier | ┨ | | | | | | | | | | | | |
| Training | ᅦ | | | | | | | | | | | | |
| Transport | | | | | | | 1 | | | | | | |
| Unapproved | _ | | | | | | | | | | | | |
| | | | L | I | L | | FA | ULT CA | TEGORY | | | | |
| Landin | ng G | ear | | | | General | | 1 11 14 10 | | | | | |
| | | Bending | | | | Bend | Г | Folio/F | Program | | Outside Dim | ensions | Pressure/Forced |
| | | Centre No | ot Concer | ntric | | BOM/Route | | Grain | | | Over/Under | tolerance | Set-up |
| | | Cracks | | | | Broken/Damage/Defect | | Hardwa | are | | Part Incorre | cí [| Temperature/Cure |
| | | Crimp/Kir | nk/Ripple | /Wave | | Burrs | | Inspect | ion Incomplete/Unqualified | | Part Lost/Mi | issing | Weld |
| [| | Cuffs | | | | Contamination | | Instruct | tions Incomplete/Unclear | | Part Moved | L | Wrong Stock Pulled |
| | | Crushing | | | | Countersink | | Misali | gned/off center | | Positioned V | Vrong | |
| | | Heat Trea | it | | | Cut Too Short | | Mislabe | eled | | Power Loss/ | Surge | Other |
| | | Inspection | n Strip in | Tube | | Drawing | L | Misrea | d | | | | |
| | | Marks/Ch | atter | | | Drill Holes | | Off-set | | | | | |
| | | Turning S | | | Ĺ | Finish | | - | Calibration | | | | |
| | | Wave/Tw | ist in Tub | e e | 1 | Fit/Function | | Out of | Sequence | | | | |

| DART AEROSPACE LTD | Work Order: | 110385 |
|------------------------------|--------------|-------------|
| Description: Bearpaw | Part Number: | D3529-1 |
| Inspection Dwg: D3529 Rev: A | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

| | | | | | - | | |
|----|----------------------------------|-----------------|---------------------|--------|--------|-------------------------|--------------|
| | spection Sheet wing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
| Α | 5.50 | +/-0.030 | 5,503 | | | MJP-04 | Ven |
| В | 0.07 x 45° | +/-0.030 x 0.5° | 0,0600 | ./ | | 111 | |
| С | R0.25 | +/-0.030 | 0 250 | | | | Radius gauge |
| D | 0.250 | +/-0.010 | 0,244 | | | 118-120 | mic |
| Е | 0.625 | +/-0.010 | 0,618 | / | | MJP-04 | Vem |
| F | 0.950 | +/-0.010 | 0,940 | | | 2 . (| . 1 3 |
| G | 1.63 | +/-0.030 | 1.615 | / | | 211 | , |
| Н | 12.14 | +/-0.030 | 12.140 | | | MJP-07 | Tape |
| | | | | | | | |
| J | 5.70 | +/-0.030 | 5, 400 | | | M.IP-04 | vern |
| Κ | 0.375 | +/-0.010 | 0,377 | ~ | | 111 | |
| ٦ | 0.525 | +/-0.010 | 0,533 | | | 31006 | Height came |
| М | 0.13 x 45° | +/-0.030 x 0.5° | 0.110 | | | 1111-04 | 1/lus |
| N | R0.50 | +/-0.030 | 0,500 | | | | Ralin Jane |
| 0 | 12.76 | +/-0.030 | 12.70 | | | MJP-07 | Tope |
| Р, | 3.38 | +/-0.030 | 3 378 | | | 1411-04 | Very |
| Q | 3.75 | +/-0.030 | 3, 454 | / | | 221 | 1.15 |
| R | 5.187 | +/-0.010 | 5 197 | | | 1.1.3 | , , , , |
| S | 5.25 | +/-0.030 | 5 253 | | | 7 6 7 | 111 |
| Т | 7.13 | +/-0.030 | 7 135 | | | CHC D2 | um |
| U | Ø0.260 | +0.006/-0.001 | 0, 260 | | | 1458-04 | ven |
| V | 0.30 | +/-0.030 | 0,3/7 | | | 6A-08 | detale dial |
| W | 0.93 | +/-0.030 | 0.932 | | | 1918-04 | Vem |
| Х | 1.30 | +/-0.030 | 1.300 | | | 1111-04 | Vem |

| Measured by: | Audited by: | ٥٤ م. ل | Prototype Approval: | N/A |
|----------------|-------------|-------------|---------------------|-----|
| Date: /4/01/14 | Date: | 14/01/17-89 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---------------------|------------|----------|
| Α | 07.05.01 | New Issue | KJ/JLM 1,A | |
| В | 08.05.06 | Dimension I removed | KJ/DD 🛠 | |

| DQA: | A: Date: | | | | | TOΔDT | | | | | | | |
|-------------------------------------|-------------------------------|-----------|-------|----------------------|----------|------------------------------|-----------|-----------------------------------|-----------------------|-------------------|---------------------------------------|--------------|------------------|
| WORK ORDER NON-CONFORMANCE / UPDATE | | | | | | | | PDATE | | | AEROSPACE | | |
| QA Closed: | | | Date: | | | | | | | W | ork Order up | date only | |
| - | | | | DISPOSITION | | | | | | | | | |
| Work Orde | Work Order: | | | | | | _ | EPARTMENT/ | _ | | | | |
| | | | | | | Rework | | | Skid-tube | Crosstube | _ | Water Jet | Engineering |
| Part N | Part No. | | | | Scrap | | | Machining | Small Fab | | d. Eng. Coor. | Quality | |
| | | | | | | Use-as-is | | Thern | noforming | Finishing | Kec/Stor | e/Packaging | Other |
| NCR No. | | | | Suspected Unapproved | | | Large Fab | Composite | j | Supplier | | | |
| Root | T | | | | Desc | ription of work order update | П | nitial | Ac | tion | Sign & | | |
| Cause | | Date | Step | Qty | | or non-conformance | l | ief Eng | | ription | Date | Verification | QC inspector |
| Design | | | | | | | | | | | | | |
| Doc/Data | | | | | | | | | | | | | <i>₹</i> |
| Equip/Tooling | | | | | | | | | | , | | | |
| Handling/Pre | | | | | | | | | | | | | |
| Material | | | · | | | | | | , | | · | . * | |
| Operator | | | | | | | | | | | | | |
| Offset/Setup | | | | | | | | | | | • | | |
| Process | | | | | • | | | | | | | | |
| Supplier | | | | | | | | | | | | | |
| Training | | | | • | | | | | | | |)#. | |
| Transport | | | | | | | | | | | | | |
| Unapproved | | | İ | | | | ļ | | | | | | 1 |
| | | | | | | | FA | ULT CA | TEGORY | | | | |
| Landi | | • | | | | General | _ | . | | - | - | | ¬ |
| | Bending Centre Not Concentric | | | | L | Bend | ┡ | 1 | Program | <u> </u> | Outside Dim | <u> </u> | Pressure/Forced |
| | | | | ntric | <u> </u> | BOM/Route | _ | 1 | Grain | | Over/Under tolerance | | Set-up |
| | Cracks | | | | <u> </u> | Broken/Damage/Defect | | Hardware | | | Part Incorrect | | Temperature/Cure |
| | Crimp/Kink/Ripple/Wave | | | /Wave | \vdash | Burrs | — | Inspection Incomplete/Unqualified | | Part Lost/Missing | | Weld | |
| | <u> </u> | Cuffs | | | - | Contamination | \vdash | Instructions Incomplete/Unclear | | | Part Moved Wrong Stock Pulled | | |
| | <u> </u> | Crushing | | | <u> </u> | Countersink | \vdash | - | Misaligned/off center | | Positioned Wrong Power Loss/Surge Oti | | Other |
| | Heat Treat | | | | - | Cut Too Short | \vdash | - | Mislabeled | | | surge L | Jotner |
| | Inspection Strip in Tube | | | Tube | - | Drawing | \vdash | Misrea | | w. | | ** | |
| | Marks/Chatter | | | | \vdash | Drill Holes | \vdash | Off-set | | | | | |
| 1 | \vdash | Turning S | | | <u> </u> | Finish | \vdash | - | Calibration | | | | |
| 1 | Wave/Twist in Tube | | | | | Fit/Function | 1 | JOUT OF | Sequence | | | | |